

Work Order ID 113434***113434***

Page 1

Friday, February 14, 2014 7:31:29 AM

Item ID: D2991-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door

Start Date: 2/7/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/7/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CLDate: 14/02/14

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2991

E

110

0.00

110

Purchasing

Purchasing

Purchasing

Memo

Issue P/O: 23024

Description: D2991-2 side door

Supplier: Delastek

Doubler batch: 113433

Ship to Delastek (1) D0589-XXX label

Batch: 113433

Certificate of Conformity and process sheet from Delastek

Ship to delastek: Qty 2 D2992-1

0.00

CL 14/02/14 ①

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

CL 14/4/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 113434***113434***

Page 2

Friday, February 14, 2014 7:31:29 AM

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Revision ID:

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Item Name: Side Door

Start Date: 2/7/2014

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Required Date: 3/7/2014

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1

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D2991

140

Identify as per dwg & Stock Location: MF

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, February 14, 2014 7:31:28 AM

Page 1

Work Order ID: 113434

113434

Parent Item: D2991-2

D2991-2

Parent Item Name: Side Door

Start Date: 2/7/2014

Required Date: 3/7/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC IPP Rev:C
10.10.13 AS PER DWG REV.E DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2991-2P

Purchased

No

110

Each

0.0000

1

1

D2991-2P

Side Door

CL14/04/14 x1

D2992-1

x2

B58333

CL14/02/14 x2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D2991-1/-2/-3 SIDE DOOR

NOTES

1) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

2) FINISH: FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 9 lbs TYP

8) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)

9) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR

10) LAYUP PER QSI 006 AND AS FOLLOWS:

MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY

11) BOND FOAM CORE USING POLYBOND B46F

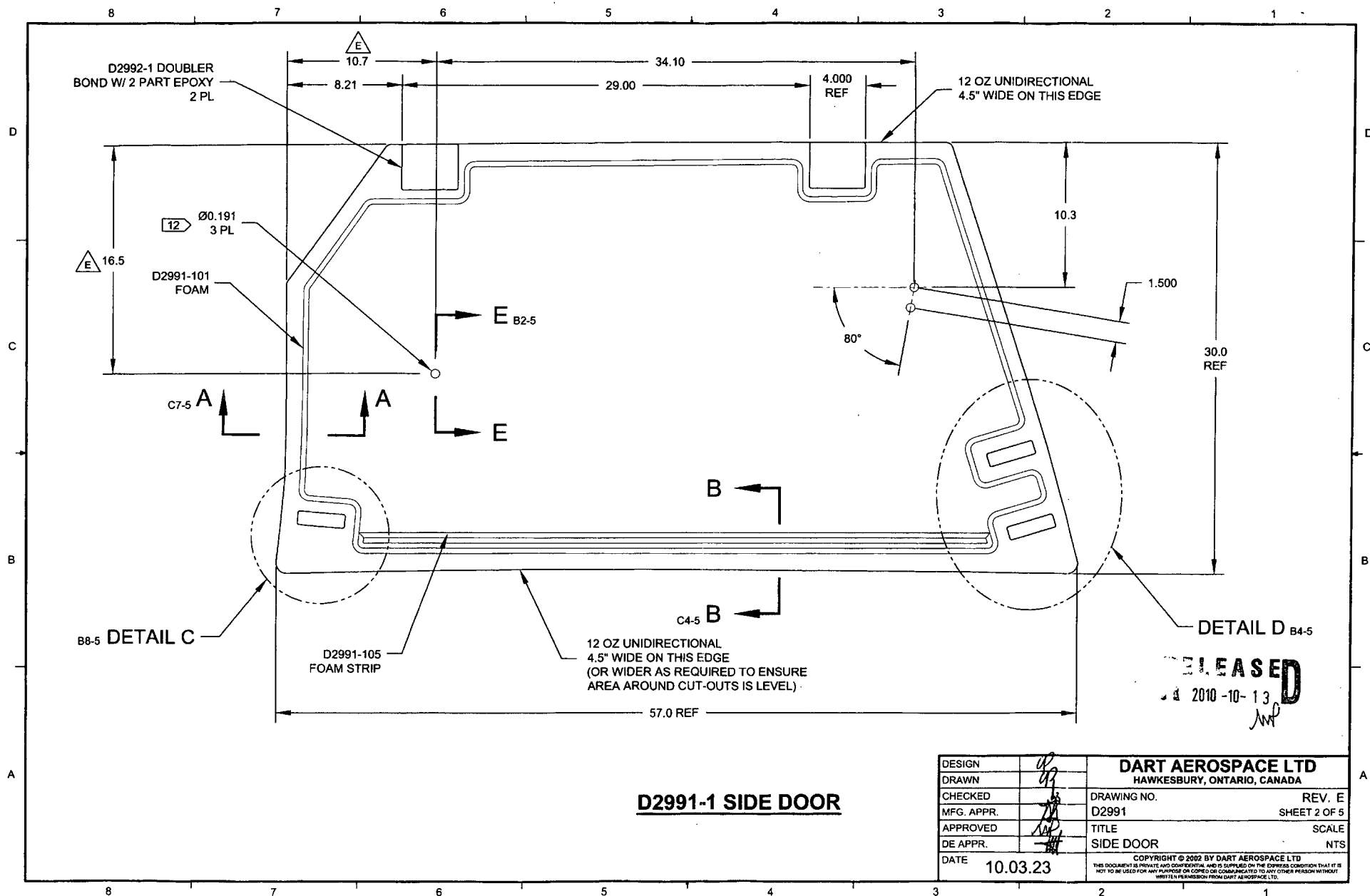
12) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.

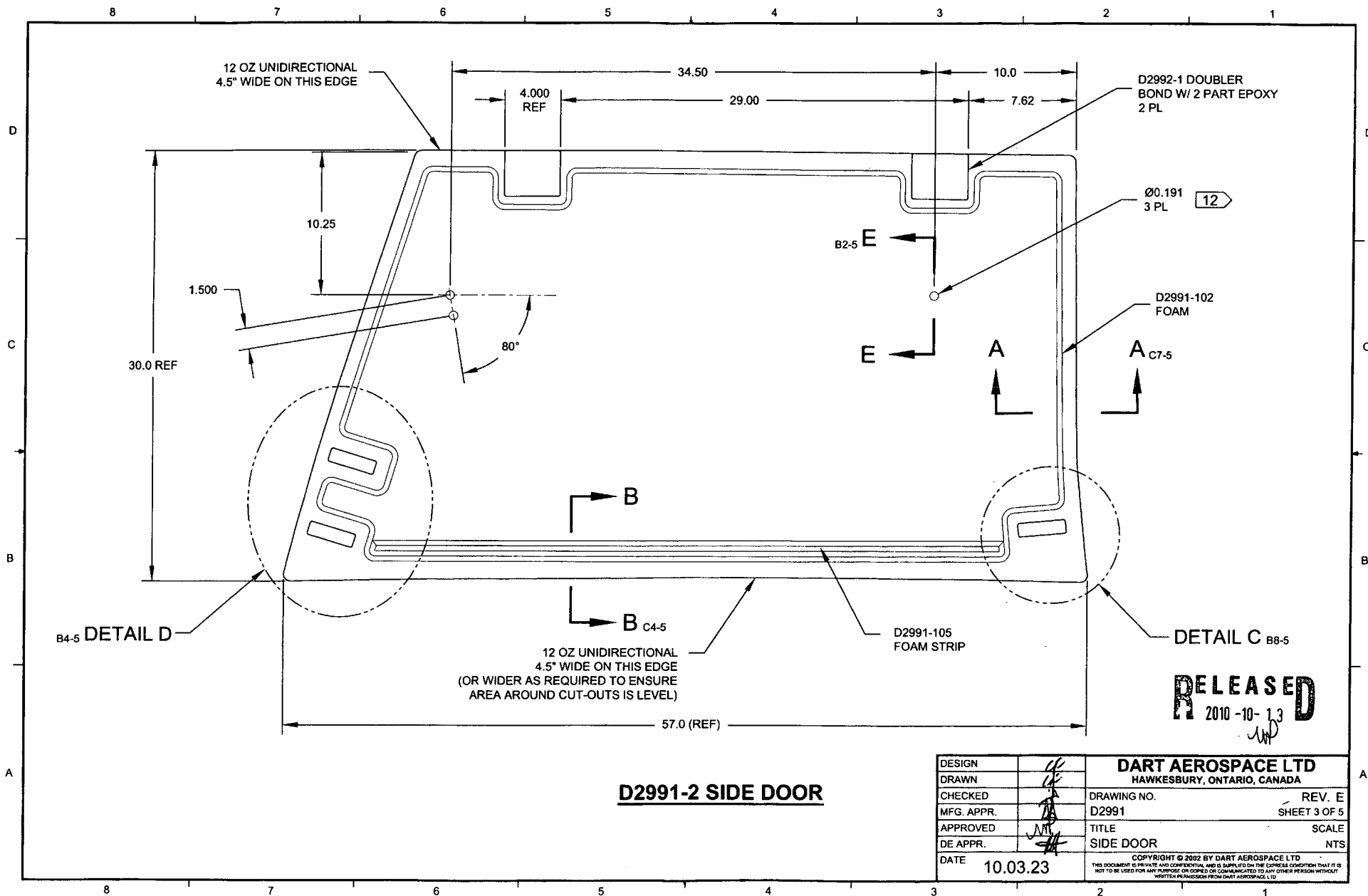
CL 14/02/14
W/O: 113434

RELEASED
2010-10-13

E	REFORMAT, MOVE HOLE: 16.5 WAS 10.25 (ZN C8-2) 10.7 WAS 10.2 (ZN D7-2), PAR 10-007	CP	10.03.23
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE

DESIGN DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. E SHEET 1 OF 5
MFG. APPR.		TITLE SIDE DOOR	SCALE NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.23		

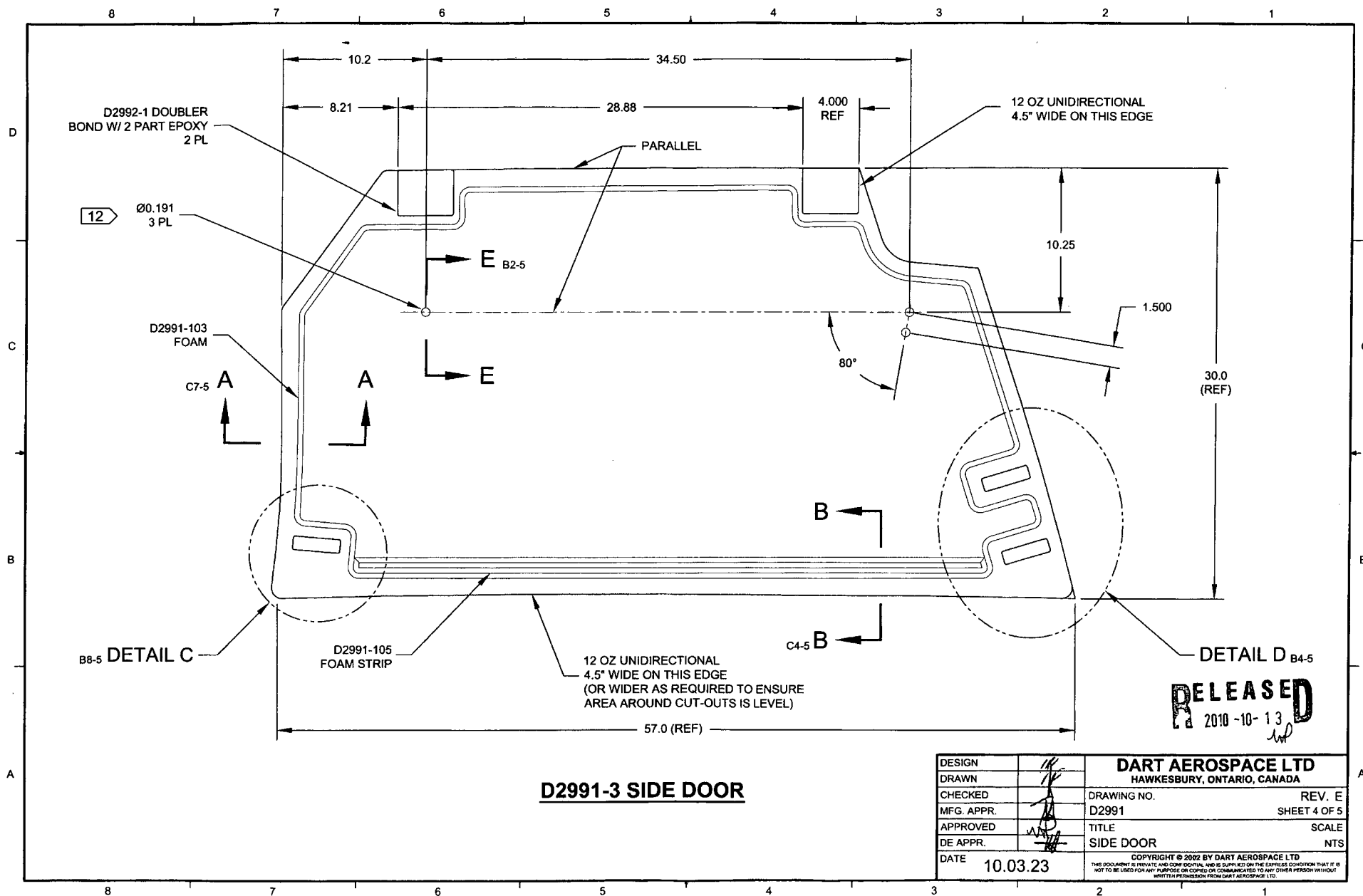


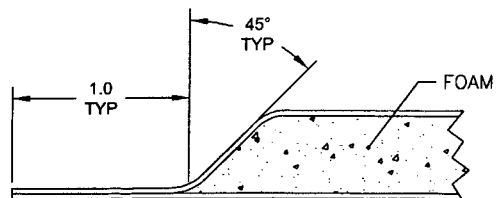


D2991-2 SIDE DOOR

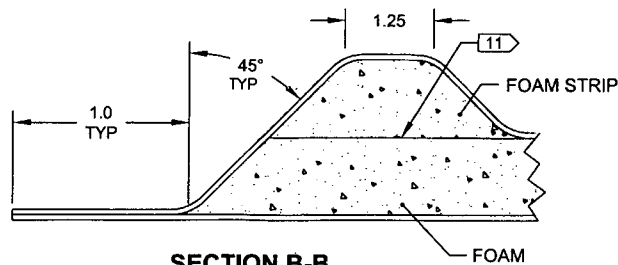
RELEASED
2010-10-13

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D2991 SHEET 3 OF 5
APPROVED		TITLE SCALE
DE APPR.		SIDE DOOR NTS
DATE	10.03.23	COPYRIGHT © 2002 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

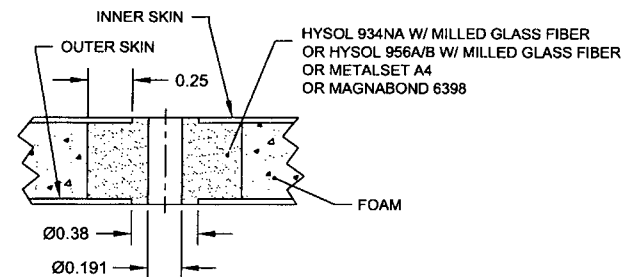




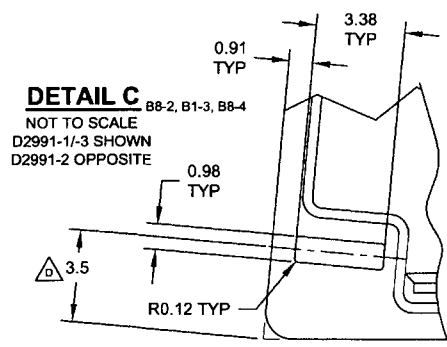
SECTION A-A
C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



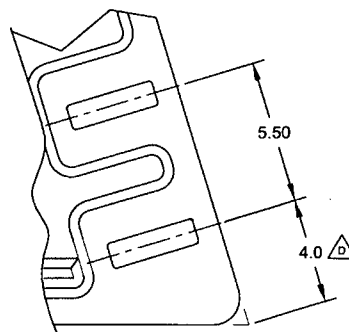
SECTION B-B
B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E
D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C
B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D
B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
2010-10-13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D2991	SHEET 5 OF 5
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DE APPR.		SIDE DOOR	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23024

Purchase Order Date 2/14/2014

PO Print Date 2/14/2014

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100
GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
02/16/14

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	819 533 5788	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	FedEx PI collect	Currency	USD
Ship Acct:		FOB	FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
D2991-2P	AS PER DWG D2991 REV. E B113434	Side Door	3/14/2014 Yes 3/14/2014		1.00 Each	\$820.00	\$820.00
						Line Total:	\$820.00
D2202-1P	AS PER DWG D2202 REV. G B113436	Side Pod Lid, 350	3/14/2014 Yes 3/14/2014		1.00 Each	\$2,890.60	\$2,890.60
						Line Total:	\$2,890.60
D2202-5P	AS PER DWG D2202 REV. G B113436	Side Pod, Base 350	3/14/2014 Yes 3/14/2014		1.00 Each	\$2,890.60	\$2,890.60

PO Instructions: Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A016 personnel qualification
A025 certification of conformance
A040 notification of quality escape
A041 quality management
A042 dart noyification by supplier

Notes

Mastering Innovation

DELASTEK

DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	56834
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200 EXT 236

Contact : Alba Panzuto

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577

Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
28-03-2014	14-02-2014	24354	Chantal Lavoie	PO23024	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Marie-Pier Montambeault, 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0077	Line #1 Side Door N° D2991-2 B113434 U of M: Chaque Dwg.: D2991 Rév.: E Lot # 60210 1	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Vendredi, 2014-03-07 13:30:18
 Utilisateur: Véronique Bouchard

Feuille de Procédé


 DELASTEK
53

Client	: DART US DART AEROSPACE	Nom Dessin	: SIDE DOOR N. D2991-2	
Numéro Job	: 60210	Numéro Article	: DKC134-0077	
Numéro	: 4361	Numéro Dessin	: --	
Numéro B.A.	:	Projet Numéro	: DK-362	
Cette fois	: 2014-03-07	Révision dessin	:	
Prsht Rev.	: NC	Matériel	: Composites	
Prem. fois	: --	Date Due	: 2014-03-14	Qté: 1 Ud UNITE
Job précédente	: 59758			
Écrit par	:			
Vérifié & Approuvé par	:			
Commentaires	: N. de dessin: D2991-2 rev. E			

E.O.: N/A

 Feuille de Procédé Rév.: 02 AMB0349 remplacé par
 AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
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1.0	AAC1616	N° 83634, Frekote Loctite Wolo
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Comment	Qty.: 0.025 UNITE(s)/Unit	Total : 0.025 UNITE(s)
	N° 83634, Frekote Loctite Wolo	# de Lot: N/A

2.0	PREP-GENERAL	Préparation du matériel
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Comment	Setup: 0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
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 Faire la préparation du moule N° DKO-0095 laisser sécher pendant 3 heures selon le
 QSI-006 et IG 0009.

Date: 11/03/14

Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
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Comment	Qty.: 1.200 KILOGRAMME(s)/Unit	Total : 1.200 KILOGRAMME(s)
	Gel Coat Blanc N° Gel 944W005	N° de Lot: 1-45003-2

4.0	AMB0286	Catalyst N° DDM-9
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Comment	Qty.: 0.0045 GALLON(s)/Unit	Total : 0.0045 GALLON(s)
	Catalyst N° DDM-9	N° de Lot: 1-27829-1

5.0	PREP-GENERAL	Préparation du matériel
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Comment	Setup: 0.00Hrs/ Run: 15.0000Min	Total Run : 0.2500Hrs
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Faire la préparation et l'application du Gel coat selon IG 0019.

Date: Vendredi, 2014-03-07 13:30:18
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE Nom Dessin: SIDE DOOR N. D2991-2
Numéro Job: 60210 Numéro DKC134-0077

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 11/03/14 Sceau:



6.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

Tissu à délaminer Release ply B

de Lot: N/A

7.0 AAC1887 Wrightlon 5200 Bleu P3

Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

Wrightlon 5200 Bleu P3

de Lot: N/A

8.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

9.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 18.00 PIED(s)/Unit Total : 18.00 PIED(s)

10.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

11.0 AMB0511 N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

12.0 AC0886 Ruban à gommer jaune #: T/IAT-200Y

Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

13.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 11/03/14 Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE Nom Dessin: SIDE DOOR N. D2991-2
Numéro Job: 60210 Numéro DKC134-0077

Numéro Job:



Séq.: Machine ou Opération: Description :

14.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

15.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0020 GALLON(s)/Unit Total : 0.0020 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst
N° DDM-9 par quantité de résine N° 411-350.

Date: 12/03/14 Sceau:



17.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire le laminage selon IF134-0009.

Date: 12/03/14 Sceau:



18.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Curing début: 8:45 Curing Fin: 8:00

Date: 12/03/14 Sceau:



19.0 AAC1611 Polybond B46F

Comment Qty.: 0.062 KIT(s)/Unit Total : 0.062 KIT(s)
Polybond B46F N° de Lot: 1-38189-1

Date: Vendredi, 2014-03-07 13:30:18
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE Nom Dessin: SIDE DOOR N. D2991-2
Numéro Job: 60210 Numéro DKC134-0077

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
20.0	DKC134-0063	Foam Core N° D2991-102(Porte D2991-2)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2991-102(Porte D2991-2) N° de Job: 60283

21.0	ASSEMBLAGE	Assemblage mécanique
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Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Sceller le Foam Core principal et la Strip de Foamcore selon IG 0105.

Coller la "Strip" de foamcore sur le foamcore principal à l'aide de résine 411-350 et DDM-9 selon le dessin.

Coller l'assemblage des foamcores selon IF134-0009 et IG 0033.

Date: 13/03/14

Sceau:



22.0	BAGGING	Faire le bagging sur la pièce
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Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 2 heures minimum.

Curing Début: 1:00 Curing Fin: 3:00

Date: 13/03/14

Sceau:



23.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

24.0	AMB0286	Catalyst N° DDM-9
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Comment Qty.: 0.0020 GALLON(s)/Unit Total : 0.0020 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

25.0	PREP-GENERAL	Préparation du matériel
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Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Vendredi, 2014-03-07 13:30:18

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SIDE DOOR N. D2991-2

Numéro Job: 60210

Numéro DKC134-0077

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date:

14/03/14

Sceau:



26.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le 2ieme laminage des tissus de verre de 9.7 oz et 13 oz. selon IF134-0009.

Date:

14/03/14

Sceau:



27.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Curing Début:

12:30

Curing Fin:

8:00

Date:

14/03/14

Sceau:



28.0

DÉMOULAGE.

Démoulage



Comment Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les rebords.

Date:

12/03/14

Sceau:



29.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le contour de la pièce à la main aux dimensions du dessin en utilisant un router muni d'un couteau 1/2 diamant.

Date:

18/03/14

Sceau:



Date: Vendredi, 2014-03-07 13:30:18
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 60210

Nom Dessin: SIDE DOOR N. D2991-2
Numéro DKC134-0077

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0205 N° EA934NA, Adhesive Hysol

Comment Qty.: 0.15 KIT(s)/Unit Total : 0.15 KIT(s)
COLLE HYSOL EA934NA

N° de Lot: 1-44693-1

31.0 AAC1540 Fibre de verre Miapoxy 66

Comment Qty.: 0.0037 GALLON(s)/Unit Total : 0.0037 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-42963-1

32.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N°DKO-0119, percer les 3 trous de .191" selon IF134-0010.

Laisser sécher jusqu'au lendemain.

Date: 18/03/14 Sceau:



33.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1-44559-2

34.0 AAC0102 Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.10 UNITE(s)/Unit Total : 0.10 UNITE(s)
Colle Araldite N° 2012 (50ml)

N° de Lot: 1-43407-2

35.0 AAC1768 N° D2992-1, Doubler

Comment Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D2992-1, Doubler

N° de Lot: 1-44818-1

36.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif ARALDITE, assembler les "Doubler" sur la pièce de composite selon le dessin.

Sceller le contour des "Doubler" à l'aide de "Putty".

Date: 18/03/14 Sceau:



37.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)
Dupont Primer N° 7704S

N° de Lot: 1-43946-3

Date: Vendredi, 2014-03-07 13:30:18

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SIDE DOOR N. D2991-2

Numéro Job: 60210

Numéro DKC134-0077

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
38.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

39.0	PRÉPARATION.	Préparation du matériel
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Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Quantité: 1 Date: 18/03/14 Sceau:



40.0	PRIMER	Application primer
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon I.G. 0008.

Date: 19/03/14 Sceau: 20 # de fiche de mélange: 6570



41.0	FINITION	Finition Générale
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Ponçer le "Primer" batisseur selon IG 0008,

Quantité: 1 Date: 20/03/14 Sceau:



42.0	AAC1021	Dupont Primer N° 7704S
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Comment Qty.: 0.2000 UNITE(s)/Unit Total : 0.2000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-43946-3

43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Comment Qty.: 0.2000 UNITE(s)/Unit Total : 0.2000 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

44.0	PRIMER	Application primer
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Fiche: 6571

Préparer et appliquer le primer selon IG 0008.

Quantité: 1 Date: 20/03/14 Sceau:



Date: Vendredi, 2014-03-07 13:30:18
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 60210

Nom Dessin: SIDE DOOR N. D2991-2
Numéro DKC134-0077

Numéro Job:



Séq.: Machine ou Opération: Description :

45.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Visual Primer



Alman IV

Faire l'inspection selon le dessin N° D2991.

Date: *21 mars 14* Sceau: 

46.0 EMBAL / ENTREPO Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage et entreposage selon IG 0057.

Date: _____ Sceau: _____

*Point "d'attache" trous libus Ø.400 sans Gelcoat.
Grafiqne dans le moule (visuel sur photo)*